

Date: Thursday, 08/05/2008 9:04:15 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE
Job Number	: 39105		
Estimate Number	: 10366		
P.O. Number	:	Part Number	: D412742013
This Issue	: 08/05/2008 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SKIDTUBES	Drawing Revision	: D
Previous Run	: 39103	Material	:
Written By	:	Due Date	: 15/06/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JUL 08-5-08</u>		
Comment	: Est Rev: A 05.10.13 New Issue KJ/JLM		
	: Est Rev: B 06-06-08 As per DSI9336 JLM		
	: Est Rev: C 07-12-03 ECN 1072 DD verified by: JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Soe/abe



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 CHG004 *005* *ECN 08-510*

2.0	39105A	FLOAT SKID ASSEMBLY
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Comment: Sub-Component FLOAT SKID ASSEMBLY
 D412-742-043 B *39105A*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	D2571	Saddle, Fwd Out 205
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2571	Saddle Fwd Outside	<i>B39006</i>

SP

5.0	D2572	Saddle, Fwd In 205
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2572	Saddle Fwd Inside	<i>B40085</i>

8/8/27

Q

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, -08/05/2008 9:04:15 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 39105

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2573

Saddle, Aft Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2573

Saddle Aft Outside

B39808

50

7.0

D2574

Saddle, Aft In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2574

Saddle Aft Outside

4099

54

8.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2876

Saddle Spacer

B36275

50

9.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2877

Saddle Spacer

B36278

50

10.0

D34031

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D3403-1

Bushing

B37542

50

11.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2747

Bolt

B39224

8/8/27

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 9:04:15 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 39105

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D35331	Set Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Set Screw

1328093

SP

13.0	AN4C6A	Bolt
------	--------	------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
16	AN4C6A	Bolt	M107242

SP

14.0	AN4C52A	BOLT
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
8	AN4C52A	Bolt	M105423

SP

15.0	AN6C12A	BOLT
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
8	AN6C12A	Bolt	M104209

SP

16.0	D36723	Phenolic Washer
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Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)
PHENOLIC WASHER

0707374

SP

17.0	AN960C416L	WASHER
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Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)
WASHER

M104008

SP

18.0	D36729	Phenolic Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PHENOLIC WASHER

135523

8/8/27

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 9:04:15 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 39105

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	AN960C616L	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER

M107242

SP

20.0	D367211	Phenolic Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
PHENOLIC WASHER

B35524

SP

21.0	MS210434	Nut
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
Nut

M108672

SP

22.0	AN4C7A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: M106302

SP

23.0	D34033	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Qty Part Number Description Batch
8 D3403-3 Bushing

B37146

B39130

SP

24.0	D3405041	Lug Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3405-041 GHW Lug

B35779

SP

25.0	D3405043	Lug Assembly
------	----------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3405-043 GHW Lug

M10 B34841

8/8/07

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial all entries

Date: Thursday, 08/05/2008 9:04:15 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 39105

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

M107287

8/8/27 SQ

27.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4 Nut

M108672

8/8/27 SQ

28.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-041

TOW RING

B41608

8/8/27 SQ

29.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3417-3

WASHER

B33519

8/8/27 SQ

30.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

WASHER

B40285

8/8/27 SQ

31.0

AN3C37A

BOLT



Comment: Qty.: 1.0000 EACH(s)/Unit Total : 1.0000 EACH(s)

BOLT

M108137

8/8/27

SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Thursday, 08/05/2008 9:04:15 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 39105

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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32.0	AN3C40A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT

M106169

8/8/27

SP

33.0	AN3C41A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT

M108084

8/8/27

SP

34.0	AN3C42A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT

M106169

8/8/27

SP

35.0	AN3C43A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT

M106227

8/8/27

SP

36.0	AN3C46A	BOLT
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
BOLT

M106169

8/8/27

SP

37.0	AN960C10L	washer
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Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
washer

M108255

8/8/27

SP

38.0	MS210433	Nut
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Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Nut

M108672

8/8/27

(X)

SP

39.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

8/8/27 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 9:04:15 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 39105

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

PACKAGING 1

PACKAGING RESOURCE #1



(1X)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: F

8/8/08

50

41.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

2008/08/09

Job Completion



11 08.08.09

B39105A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*12	*AN3C6A	*BOLT
4		*8	*AN3C7A	*BOLT
5		*44	*AN960C10L	*WASHER
21A		*1	*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1	*D3566-1	*GASKET
22A		*1	*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1	*D3566-1	*GASKET
23A		*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1	*D3566-5	*GASKET
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24A		**1	**D3564-13	**WEARSHOE
24B		**1	**D3566-13	**GASKET
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25A		**1	*D3537-1	**WEARPAD
25B		**1	*D3553-1	**GASKET
26A		**1	*D3537-7	**WEARPAD
26B		**1	*D3553-3	**GASKET
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**12	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 19)

(CONTINUED FROM PAGE 18)

Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46	16		D3403-1	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49	8		AN4C52A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	16		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		ANC47A	BOLT
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C46A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

Date: Thursday, 08/05/2008 9:04:15 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 39105
 Estimate Number : 10366
 P.O. Number :
 This Issue : 08/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SKIDTUBES
 Previous Run : 39103

Drawing Name : FLOAT SKIDTUBE
 Part Number : D412742013
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 15/06/2008 Qty: 1 Um: Each

Written By :
 Checked & Approved By : JUD 08-5-08
 Comment : Est Rev: A 05.10.13 New Issue KJ/JLM
 Est Rev: B 06-06-08 As per DSI9336 JLM
 Est Rev: C 07-12-03 ECN 1072 DD verified by: JLM

REFERENCE ONLY

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

JUD 08-5-08
Photocopy bluefile and create labels per PPP D412-742-013 CHG004

2.0 39105A

FLOAT SKID ASSEMBLY



Comment: Sub-Component FLOAT SKID ASSEMBLY

D412-742-043 B

3.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D2571

Saddle, Fwd Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle Fwd Outside	

5.0 D2572

Saddle, Fwd In 205



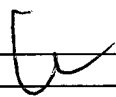
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle Fwd Inside	

Date: Thursday, 07/08/2008 1:45:35 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT SKID ASSEMBLY
Job Number :	39105A		
Estimate Number :	10756		
P.O. Number :		Part Number :	D412742043
This Issue :	07/08/2008	Drawing Number :	D3391
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	08/05/2008	Drawing Revision :	G
Previous Run :	39103A	Material :	
Written By :		Due Date :	15/06/2008
Checked & Approved By :		Qty:	1 Um: Each
Comment :	Est Rev A 05.10.13 New Issue KJ/JLM Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC Est Rev:C 07-05-28 As per Rev F JLM Est Rev:D 07-12-04 ECN 1072 DD verified by:JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :



2.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

 **REMOVE/CLEAN LPS FROM TUBE
FORWARD TUBE TO SKIDTUBE CELL** 

- FZ 08/08/11 ①

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391
A/R LPS-3 M107192

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M108801
Expiry date: 08/10

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M104251
A/R Sikaflex-241/-291 M108801
Expiry date: 09/10

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

13 08-08-18 X①

Date: Thursday, 07/08/2008 1:45:35 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 39105A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

2.1

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1

A) -DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS SHOWN ON DSI 9364.

INSTALL D3591-1 BUSHING B 3514

B) - DEBURR ALL HOLES

- TOUCH UP ALODINE

- TOUCH UP PAINT

C) - RECOAT WITH LPS3 B 11107912

RETURN TUBE TO HAND FINISHING

-CONTINUE ON ASSEMBLY PER SEQ 2.0

8-8-18

08-08-18

2.2

D35911

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing

3.0

D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

Qty Part Number Description Batch

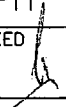
1 D3391-023 Mid Tube Assembly 1335770

08-08-18

Job Completion



REFERENCE ONLY

DESIGN PH	DRAWN BY AJS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED	DRAWING NO. DSI 9364	REV. C SHEET 1 OF 1
DATE 08.08.06		TITLE BUSHING INSTALLATION	SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	
C	08.08.06	ADDED CHG 005 & SUBS TO EFFECTIVITY	

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. D AND ICA-D412-742 REV. 3

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

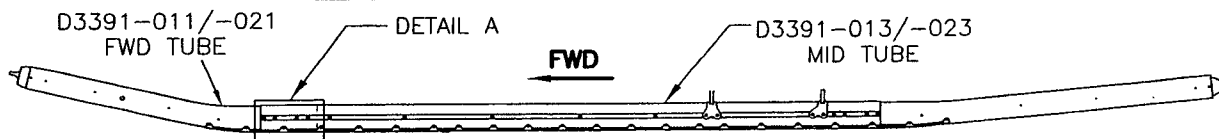
REF EASA STC: IM.R.S.01126

TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 OR CHG 005 AND SUBSEQUENTS HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

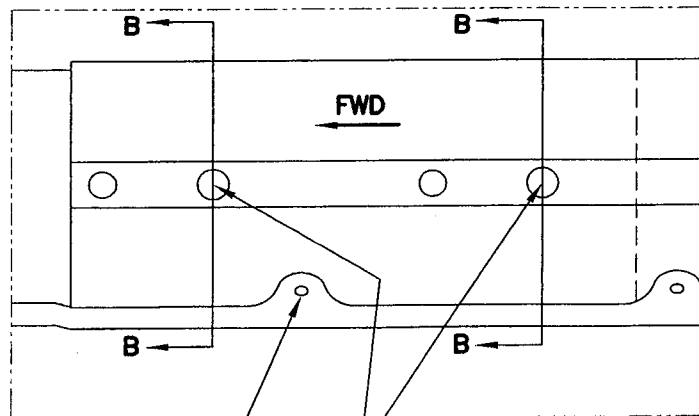
CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001, CHG 003 AND CHG 004 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ($\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. **DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.**
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING



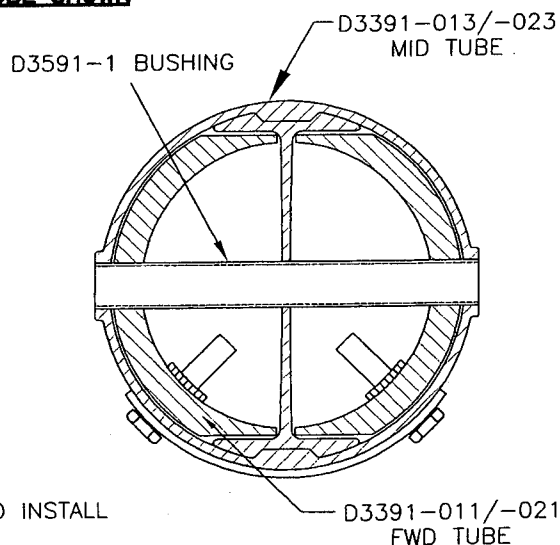
D412-742-011/-013 SKIDTUBE SHOWN



ENSURE BOLT IS FASTENED PRIOR TO TRANSFER DRILLING (REF)

OPEN TO $\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$ AND INSTALL D3591-1 BUSHING (2 PLACES)

DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION



SECTION B-B

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Date: Thursday, 08/05/2008 9:04:28 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT SKID ASSEMBLY
Job Number :	39105A		
Estimate Number :	10756		
P.O. Number :		Part Number :	D412742043
This Issue :	08/05/2008	Drawing Number :	D3391
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1/1	Drawing Revision :	G
Previous Run :	39103A	Material :	
Written By :		Due Date :	15/06/2008
Checked & Approved By :	<u>JLD 08.5.08</u>	Qty:	1 Um: Each
Comment :	Est Rev A 05.10.13 New Issue KJJ/JLM Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC Est Rev:C 07-05-28 As per Rev F JLM Est Rev:D 07-12-04 ECN 1072 DD verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003

2.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

**Comment:** HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M107912

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M108801Expiry date: 08/10

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M104251A/R Sikaflex-241/-291 M108801Expiry date: 08/10

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

JLD 08-08-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 9:04:28 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 39105A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-023 Mid Tube Assembly

040523

91

4.0

D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-025 Aft Tube Assembly

1340524

92

5.0

D35641

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 039286

93

6.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch: 040431

94

7.0

D35643

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

034052

95

8.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

040430

96

08.08.18

91

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 9:04:28 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 39105A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 640401 *js*

10.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

BOLT

Batch: m/108599 *js*

11.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

BOLT

Batch: m/105300 (x12) *js*

12.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

Batch: m/107376 *js*

13.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

washer

Batch: m/1086762 *js* 08-08-15 (21)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: PPP 39 105 *js* 08-08-15 (21)

PPP Rev:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 9:04:29 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 39105A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten signature and date: 08/08/09

Job Completion



Handwritten date: 08-08-29

Dart Aerospace Ltd

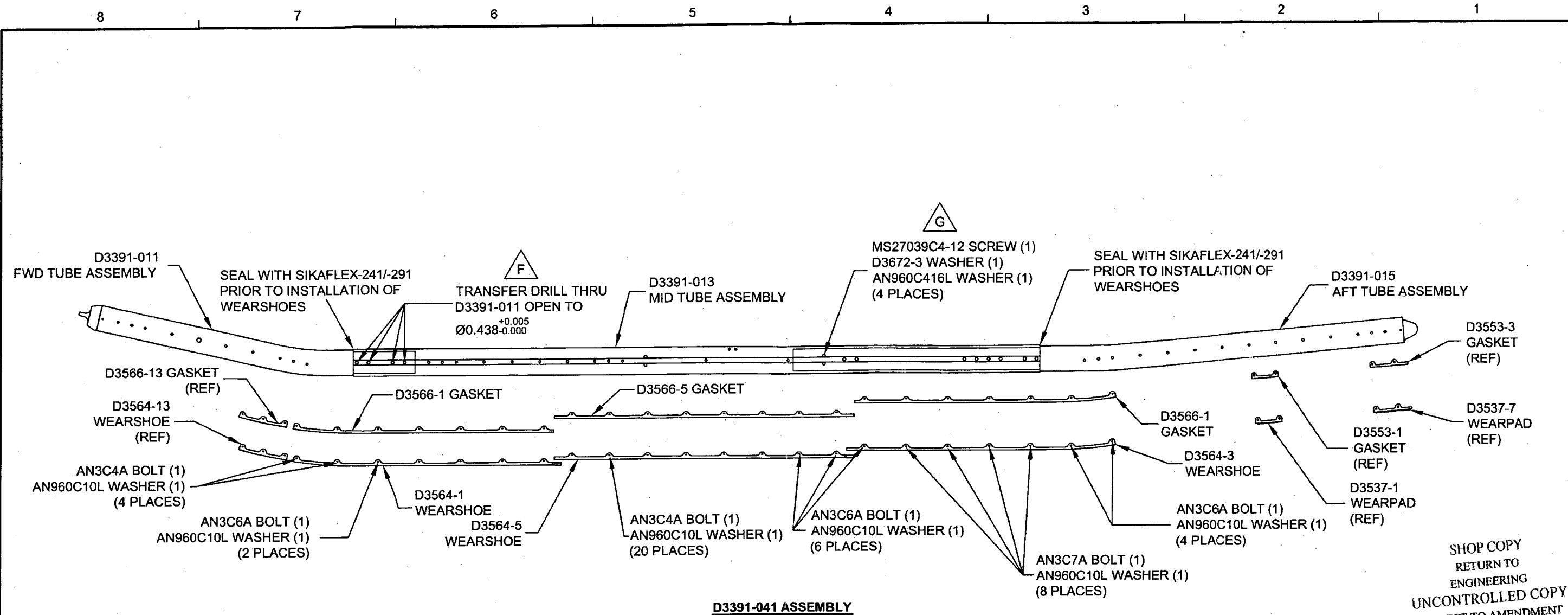
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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NO. 39105A

RELEASED
27-11-06 MP

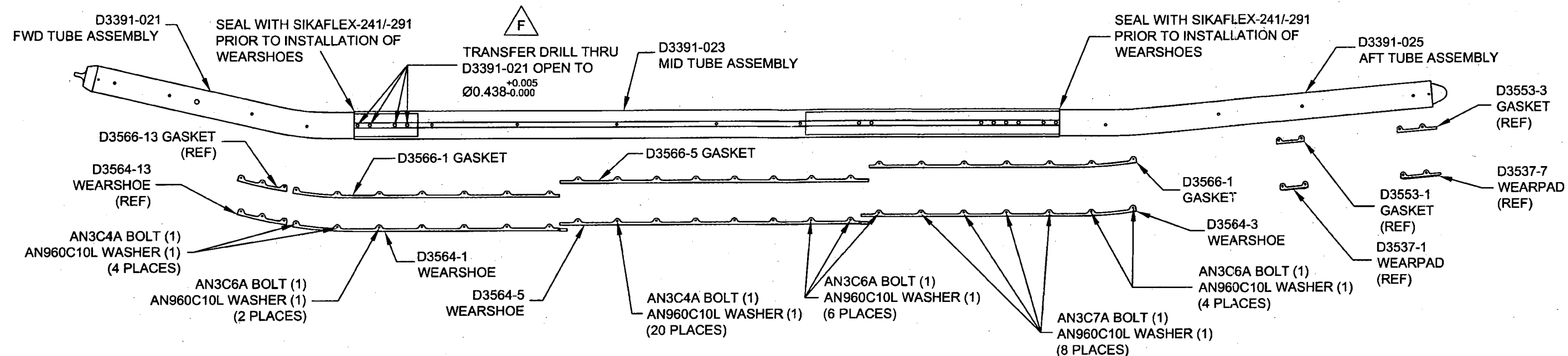
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

DESIGN	REV.	DESCRIPTION	BY	DATE
G		REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F		ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E		CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D		UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C		LENGTHEN AFT EXTENSION	PH	05.09.27
B		DRAWING UPDATES	PH	05.06.10
A		NEW ISSUE	PH	05.02.07
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3391 REV. G SHEET 1 OF 8 TITLE 412 FLOAT SKIDTUBE SCALE NTS DATE 07.07.31 <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>				



D3391-043 ASSEMBLY

RELEASED
07.11.21

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

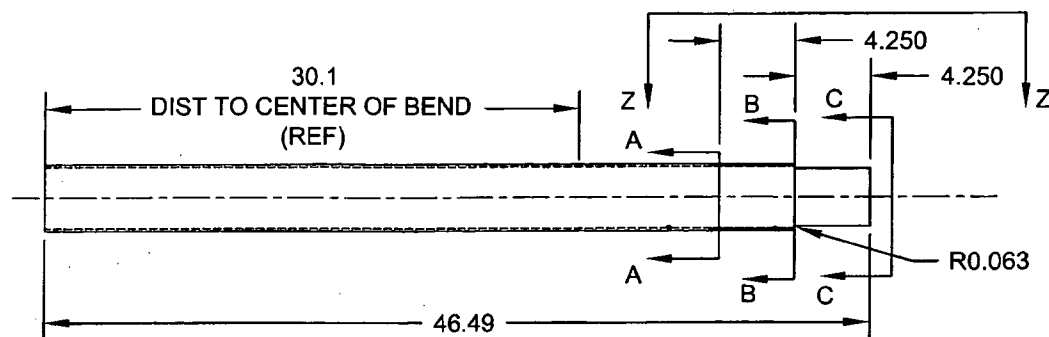
QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

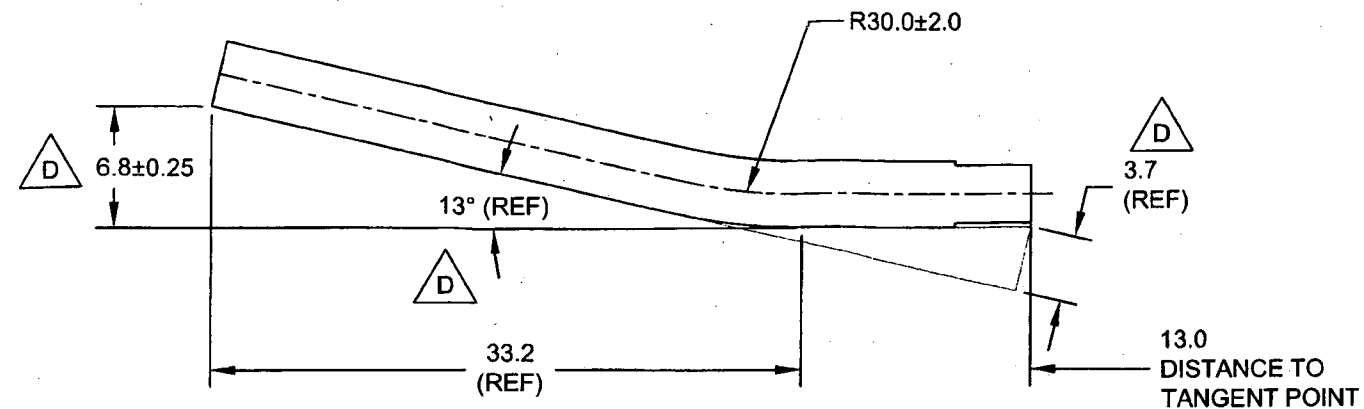
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

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NO. 391054

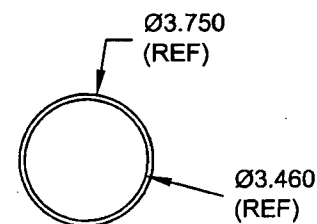
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	JLC	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. G
MFG. APPR.	RD	D3391	SHEET 2 OF 8
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



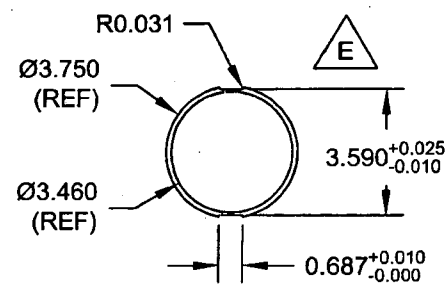
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



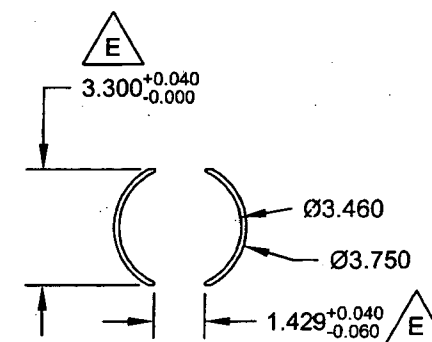
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



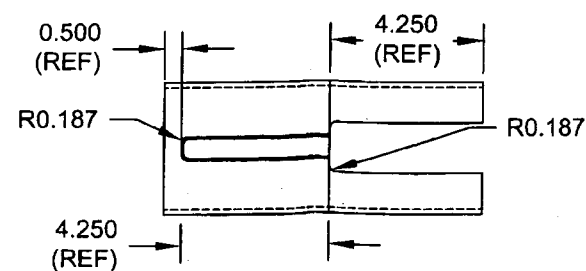
SECTION A-A
(SCALE 1:5)



SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)

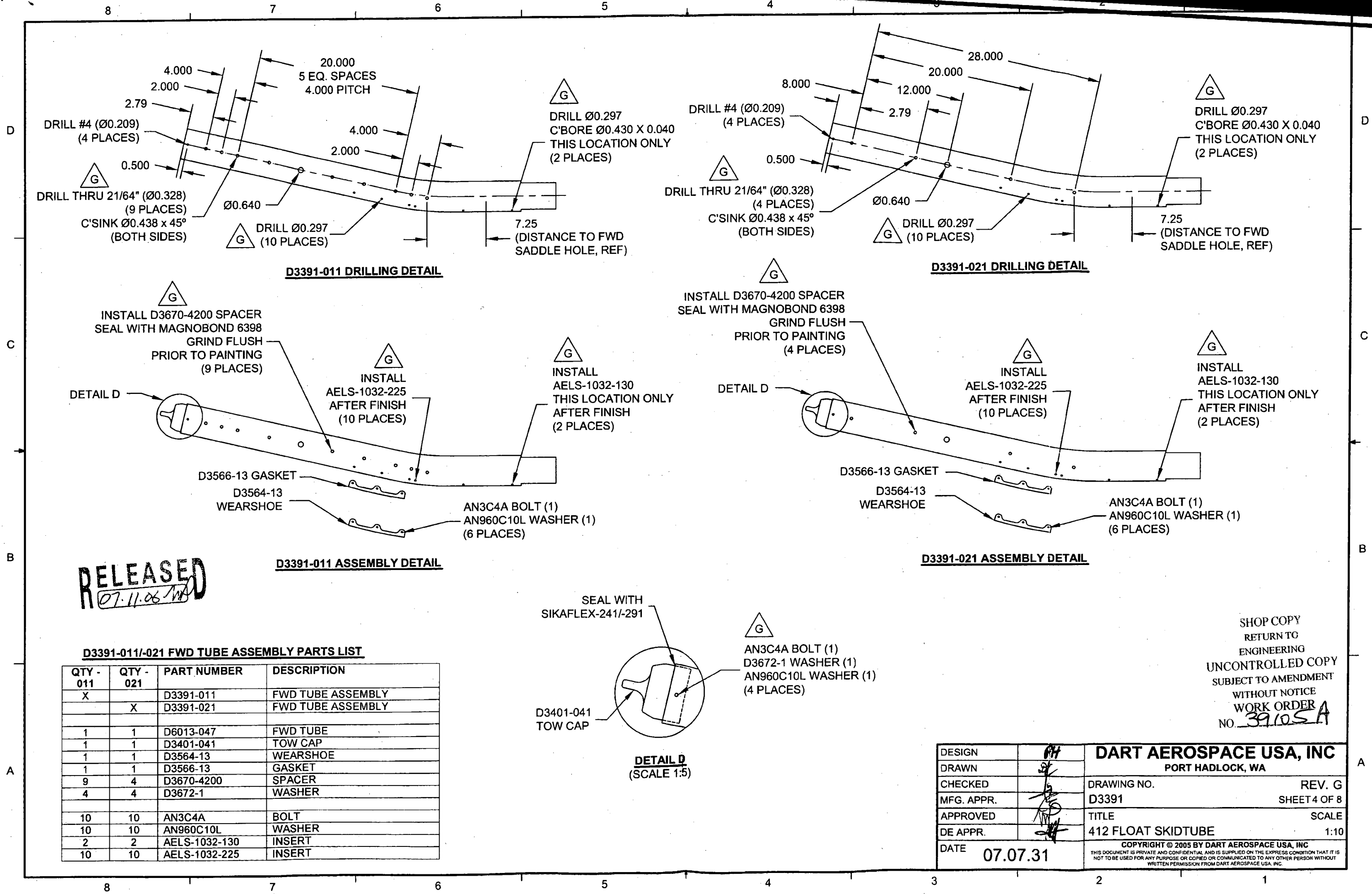


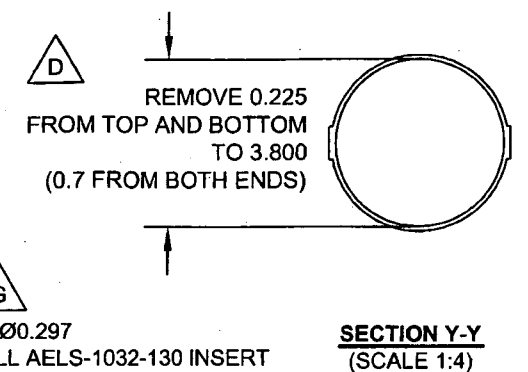
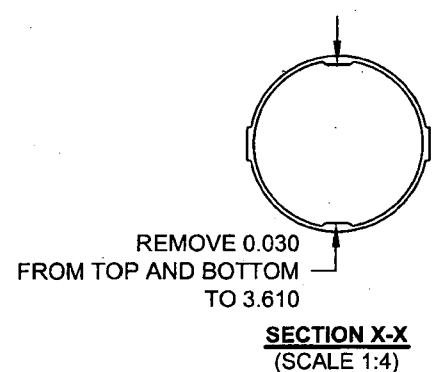
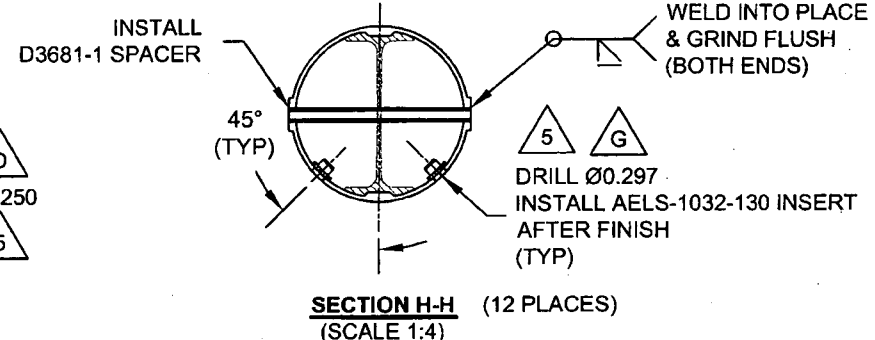
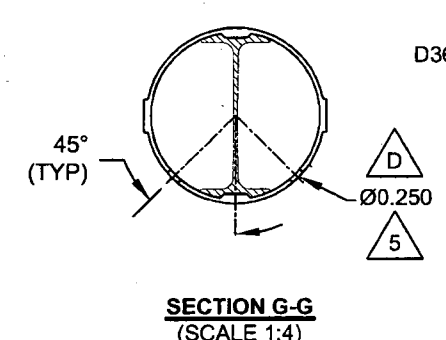
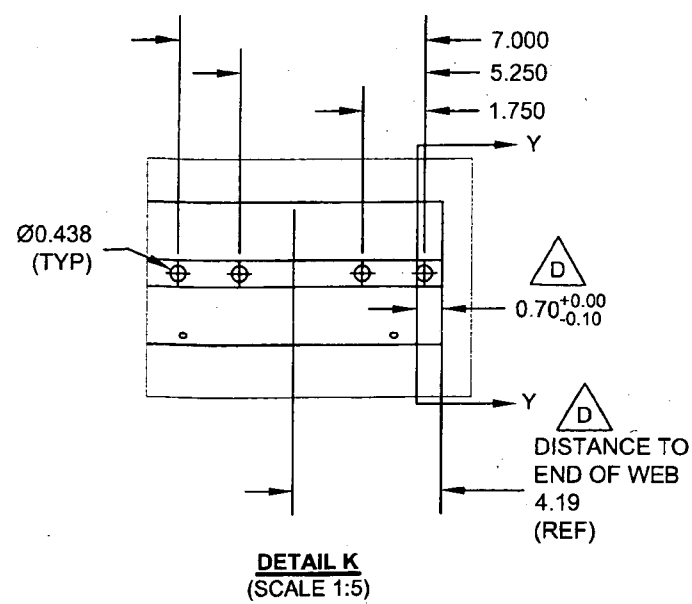
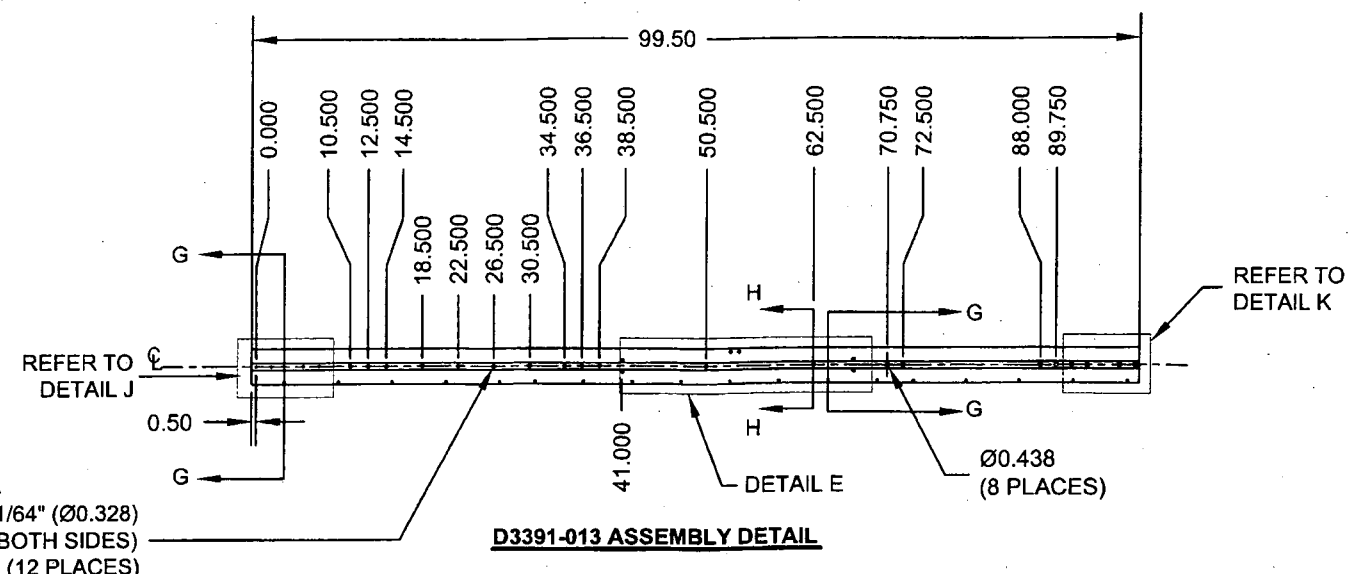
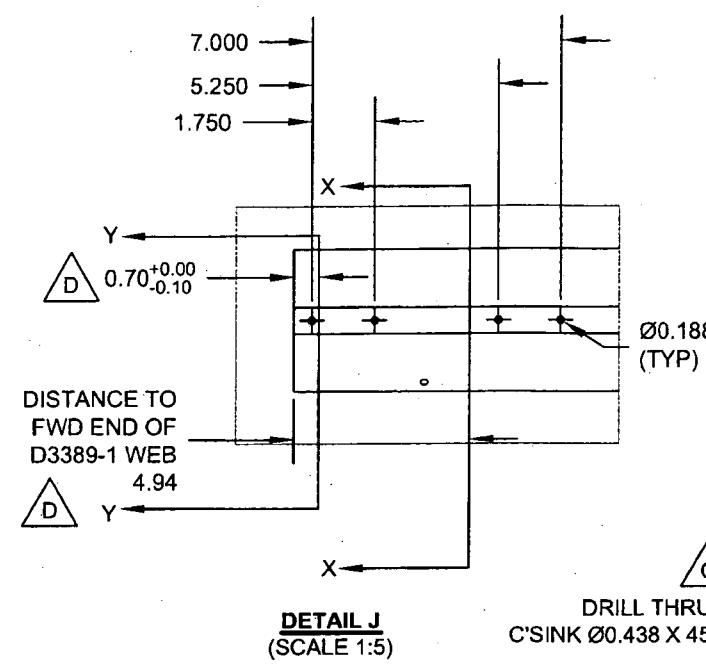
VIEW Z-Z
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RELEASED
07-11-08

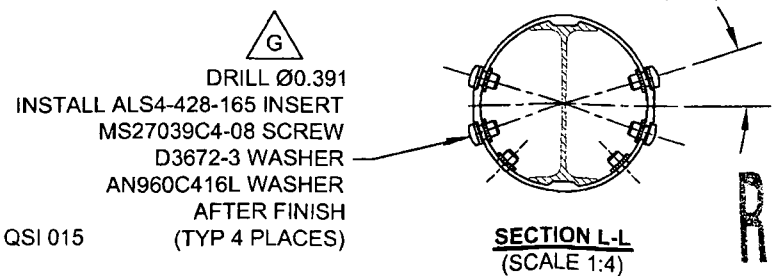
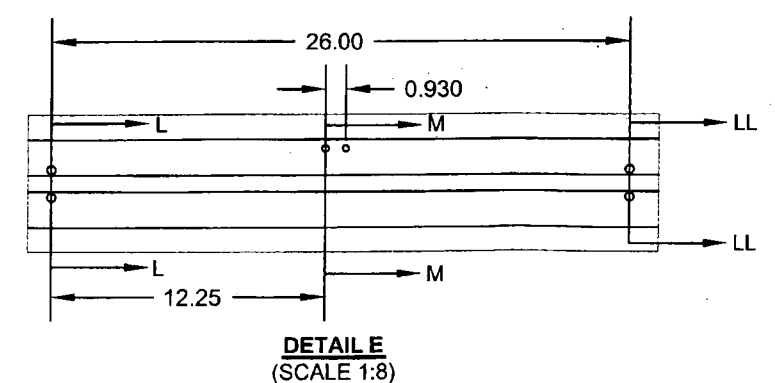
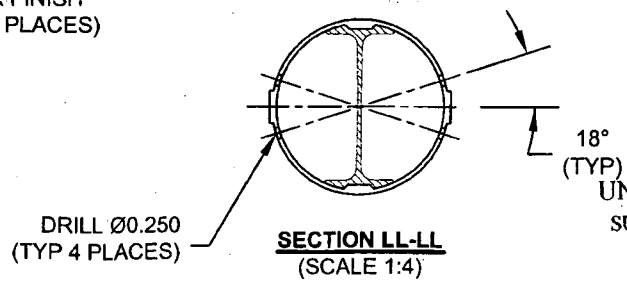
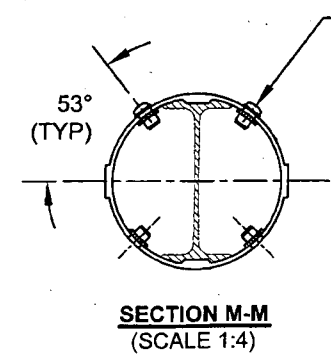
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WORK ORDER
NO. 39105-A

DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	1:10
DATE	07.07.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
(TYP 4 PLACES)



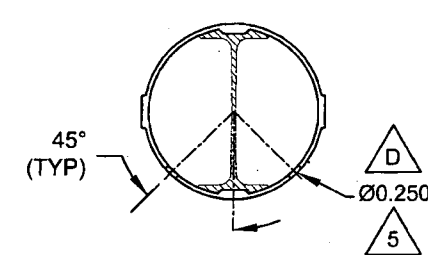
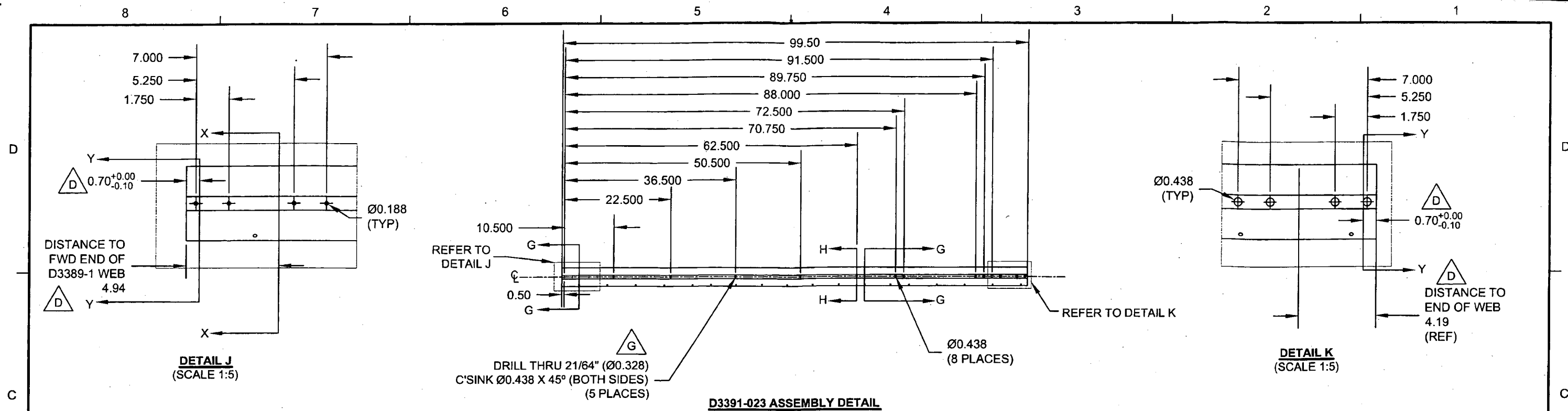
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

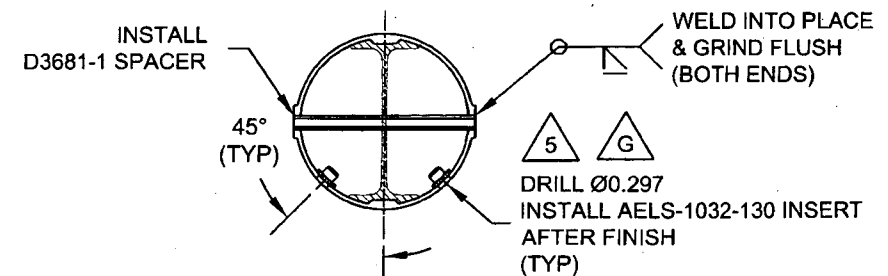
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DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JP	D3391	SHEET 5 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	412 FLOAT SKIDTUBE	1:20
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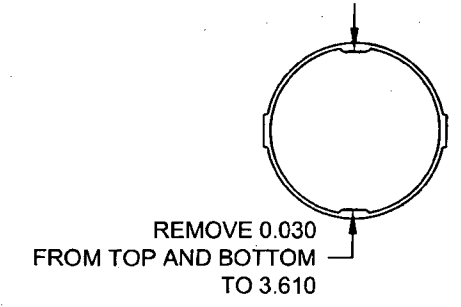
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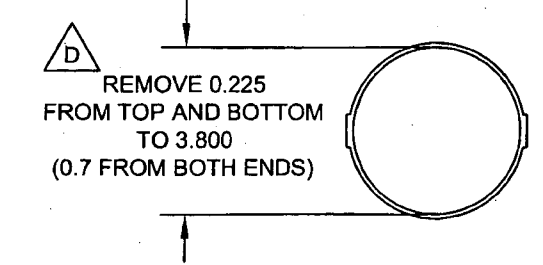
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(SCALE 1:4)



SECTION H-H
(SCALE 1:4)



SECTION X-X
(SCALE 1:4)



SECTION Y-Y
(SCALE 1:4)

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D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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